

Date: Thursday, 23/04/2009 3:30:39 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	DOOR HANDLE KIT
Job Number :	47442		
Estimate Number :	10292		
P.O. Number :		Part Number :	D412698013
This Issue :	23/04/2009	Drawing Number :	IIN D412-698 REVE
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	//	Drawing Revision :	D
Previous Run :	46457	Material :	
Written By :		Due Date :	05/05/2009
Checked & Approved By :	<u>JLD 09.04.24</u>	Qty:	3 <i>per</i> Um: Each
Comment :	Est Rev: C Removed Manufacturing 05-11-06 JLM Est Rev: D change to rev D ECN 1104 08-01-28 DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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for JLD 09/05/04



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-698-013CHG001

8 09/15/27

2.0	47442A	HANDLE
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Comment: Sub-Component HANDLE

4 x D3203-1 Batch 47442A

9/5/24

SP

3.0	47442B	DOUBLER ASSEMBLY
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9/5/24



Comment: Sub-Component DOUBLER ASSEMBLY

1 x D3220-041 Batch 47442B

46457B

8 47442B x 2

SP

4.0	47442C	DOUBLER ASSEMBLY
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9/5/24



Comment: Sub-Component DOUBLER ASSEMBLY

1 x D3220-042 Batch 47442C

1343430

135568C

46502

SP

5.0	47442D	DOUBLER
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2x 1347442

9/5/27

2x2

3x

Comment: Sub-Component DOUBLER

2 x D3220-3 Batch 47442D

1346337

9/5/24

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR HANDLE KIT

Job Number: 47442

Part Number: D412698013

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

7.0

AN960JD416L

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)
Pick: Packing Kit

Qty Part Number Description Batch

8 AN960JD416L Washer

M110153

9/15/11

SP

8.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)
Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4

Nut (or -4)

M110950

9/15/11

SP

9.0

MS24694S98

Screw



Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)
Pick: Packing Kit

Qty Part Number Description Batch

16 MS24694-S98

Screw

M111453

9/15/11

SP

10.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

20515127 (x3)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-698-013

Location: _____

D

104/10/22 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR HANDLE KIT

Job Number: 47442

Part Number: D412698013

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/27 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf
09-05-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

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WORK ORDER

NO. 4142

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Revision: **E**

Date: 08.05.01

7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

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NO. 47442

8.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 412-030-300-XXX COMPOSITE DOORS)

Qty -019	Qty -021	Qty -031	Qty -032	Qty -033	Qty -035	Part Number	Description
X						D412-698-019	BEARING OVERHAUL KIT
	X					D412-698-021	REPLACEMENT SHIM KIT
		X				D412-698-031	CABIN DOOR ROLLER KIT, LH
			X			D412-698-032	CABIN DOOR ROLLER KIT, RH
				X		D412-698-033	REPLACEMENT DOOR TRACK KIT
					X	D412-698-035	DOOR HANDLE KIT
7						D3121-21	BOLT
5						D3121-241	BEARING ASSEMBLY
1						D3137-3	GUIDE
1						D3137-5	WASHER
2						D3183-045	BEARING ASSEMBLY
	3					D3238-1	SHIM
	1					D3238-3	SHIM
	2					D3238-5	SHIM
	6					D3238-11	SHIM
	2					D3238-13	SHIM
	4					D3238-15	SHIM
		1				D3121-143	BRACKET ASSEMBLY
			1			D3121-144	BRACKET ASSEMBLY
		1	1			D3137-043	BRACKET ASSEMBLY
		1				D3183-043	BRACKET ASSEMBLY
			1			D3183-044	BRACKET ASSEMBLY
		1	1	1		D3202-3	COVER
		3	3			D3674-041	BRACKET ASSEMBLY
		9	9	9		D3675-1	BRACKET
					2	D3779-041	HANDLE ASSEMBLY
					2	D3779-3	PLATE
					2	D3779-043	HANDLE ASSEMBLY
					12	AN525-832R8	SCREW
					12	AN960JD10L	WASHER
					12	MS21042L3	NUT
					12	MS24694-S58	SCREW
1						MS24694-S101	SCREW

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